Dart Aerospace Ltd. Tuesday, 11/21/2006 1:36:00 PM Kim Johnston User: **Process Sheet** : BUSHING Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 29620 **Estimate Number** : 10175 : NIA : D2570 **Part Number** P.O. Number S.O. No. : HIA : D2570 REV A This Issue : 11/21/2006 **Drawing Number** : N/A **Project Number** Prsht Rev. : MACHINED PARTS First Issue Type **Drawing Revision** : 28480 Material **Previous Run Due Date** : 12/5/2006 Qty: 500 Um: Written By Checked & Approved By : Est Re-format; Removed finishing; Material change K Comment J **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** M303R0750 303 Round Bar .75" 1.0 Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch 102 314 HARDINGE HARDINGE CNC LATHE SMALL 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

. SECOND CHECK







PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 5752





4.0

5.0

06/11/26

Each

Da	rt	Δ۵	ro	spa	Ce		td
υa		~~		SUC	いしせ	_	.u

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector					
			:									
							·					
							:					
Part No) :	PAR #: Fault Category:	NCR: Yes	No DO	Δ-	Date:	:					

QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	-	Verification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
	·									
				•		~ ?		;		

NOTE: Date & initial all entries

Date:

Tuesday, 11/21/2006 1:36:00 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29620

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





505

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	Ltd							:
W/O:		**************************************	WC	RK ORDER CHANGE	S				:
DATE STEP		PF	ROCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									:
									!
									; ;
				·	L				
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :		_ Date:	!
					QA: N	I/C Closed:		Date: _	i :
NCR:			WORK ORDE	ER NON-CONFORMAI	NCE (NCF	₹)			(
		Description of NC		Corrective Action Section B			ation Approval	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
							,		!
								:	
					·				;

		Description of NC	1	OCCION D	Verification Approval		Annroyal	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
					,			
								!
								i
								:
			i di					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 29620
Description: Bushing	Part Number: D2570
Inspection Dwg: D2570 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	,801	6			
0.060	+/-0.005	,061	/			
R0.010	+0.010/-0.000	.010	/			
Ø0.425	+0.000/-0.002	.424	/			
Ø0.257	+0.005/-0.000	,259				
Ø0.750	+/-0.010	.744				
0.030 x 20°	+/-0.010	030 × 200				
			•			

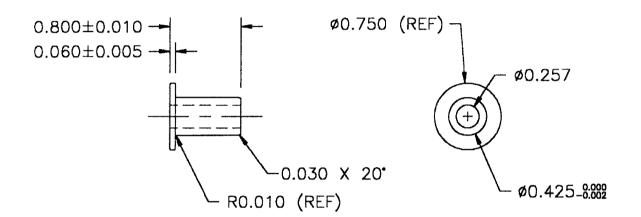
~				
Measured by:	Audited by:	J.L	Prototype Approval:	N/A
Date: 06/11/27	Date:	06/11/22	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF 1.A	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	· 14



DESIGN	DRAWN BY	L	AEROSPACE LTD NTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
14	MS.	D2570	SHEET 1 OF 1
DATÉ		TITLE	SCALE
96:09:16		BUSHING	1:1

RELEASED



BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 — 0.75 DIA STOCK

SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 29620